

Date: Thursday, 2/9/2006 1:42:29 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 350/212/130 BASKET LID		
Job Number	: 25758B					
Estimate Number	: 10193					
P.O. Number	: N/A			Part Number	: D2512	
This Issue	: 2/9/2006		S.O. No.	: N/A		
Prsh Rev.	: NC			Drawing Number	: D2512 REV D1	
First Issue	: N/A		Type	: LARGE FAB ASSY		
Previous Run	: 25756B			Project Number	: N/A	
Written By	: See Comment Below			Drawing Revision	: D1	
Checked & Approved By	: S. OZ. 10			Material	: N/A	
Comment	: Rev Est:M 02.01.31 Added D2012-117 for D130-701-041 KJ/ RF			Due Date	: 3/7/2006	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W	
		Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)	
		Pick: 3/4"x3/4" 304/316 SS tube .063" wall	
		Batch: BM100023	PD 06-03-16
2.0	D31663	Basket Hoop	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick: Qty Part Number Description Batch	(1)
		1 D3166-3 Basket Hoop B255896	PD 06-03-16
3.0	D2506	Placard	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick: Qty Part Number Description Batch	(1)
		1 D2506 Label Plate B24875	PD 06-03-16
4.0	D23271	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick: Qty Part Number Description Batch	(1)
		2 D2327-1 Bushing B24873	PD 06-03-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:42:29 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 25758B

Part Number: D2512

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D22321 Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2232-1	Hinge plate	B23445

(2)

PD

06-03-16

6.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2581	Mounting Bracket	B25634

(2)

PD

06-03-16

7.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty	Part Number	Description	Batch
18 sf	M304EX0.75-16F	Expanded Metal	M1000230

PD

06-03-21

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

4-D2012-117 is included in D3172-041 EC130 Basket Base BOM.
EC130 Basket only

Pick:

Qty	Part Number	Description	Batch
2	D2012-117	Clevis	

(1)

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

PD 06-03-21

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/03/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 350/212/130 BASKET LID

Job Number: 25758B

Part Number: D2512

Job Number:



Seq. #: Machine Or Operation:

Description :

9.0 QC9/6 DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

DC 06/03/21 ①

10.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M DC 06/03/23 ①

11.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Spray: M19640
Batch: M100037 ① 06/03/23 ①

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

① 06/03/28 ①

Job Completion



U 06/03/28

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries



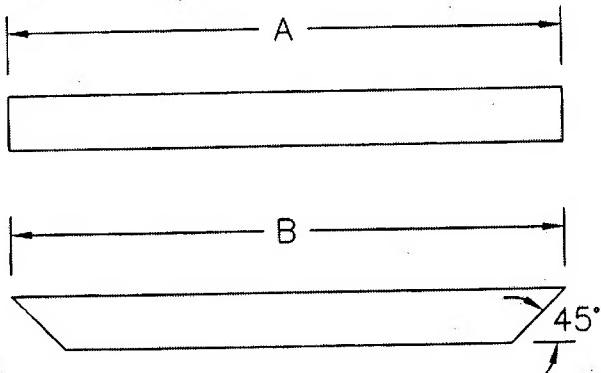
DESIGN BW	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE NTS

RELEASED
01.04.27 *f*

A	95.11.21	NEW ISSUE
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074
D	01.04.19	CHANGE HINGE
D1	01.04. 03.01. 20	ADD D2012-117 FOR D130-701-041
D2	01.04. 09.20	TACK WELD ANTI-SKID AREA

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



D2512-1/-3/-5/-7

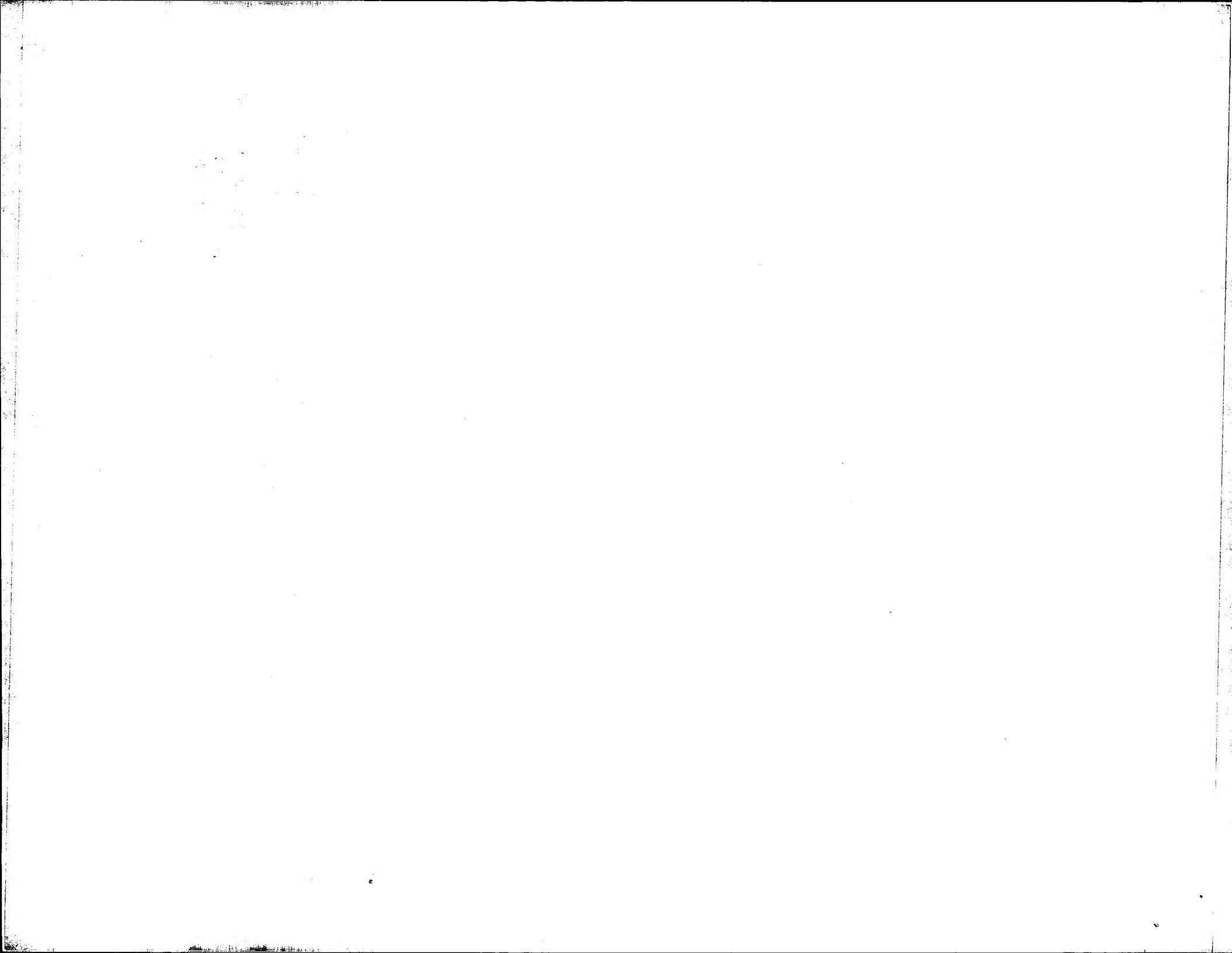
CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
NO. 25758B

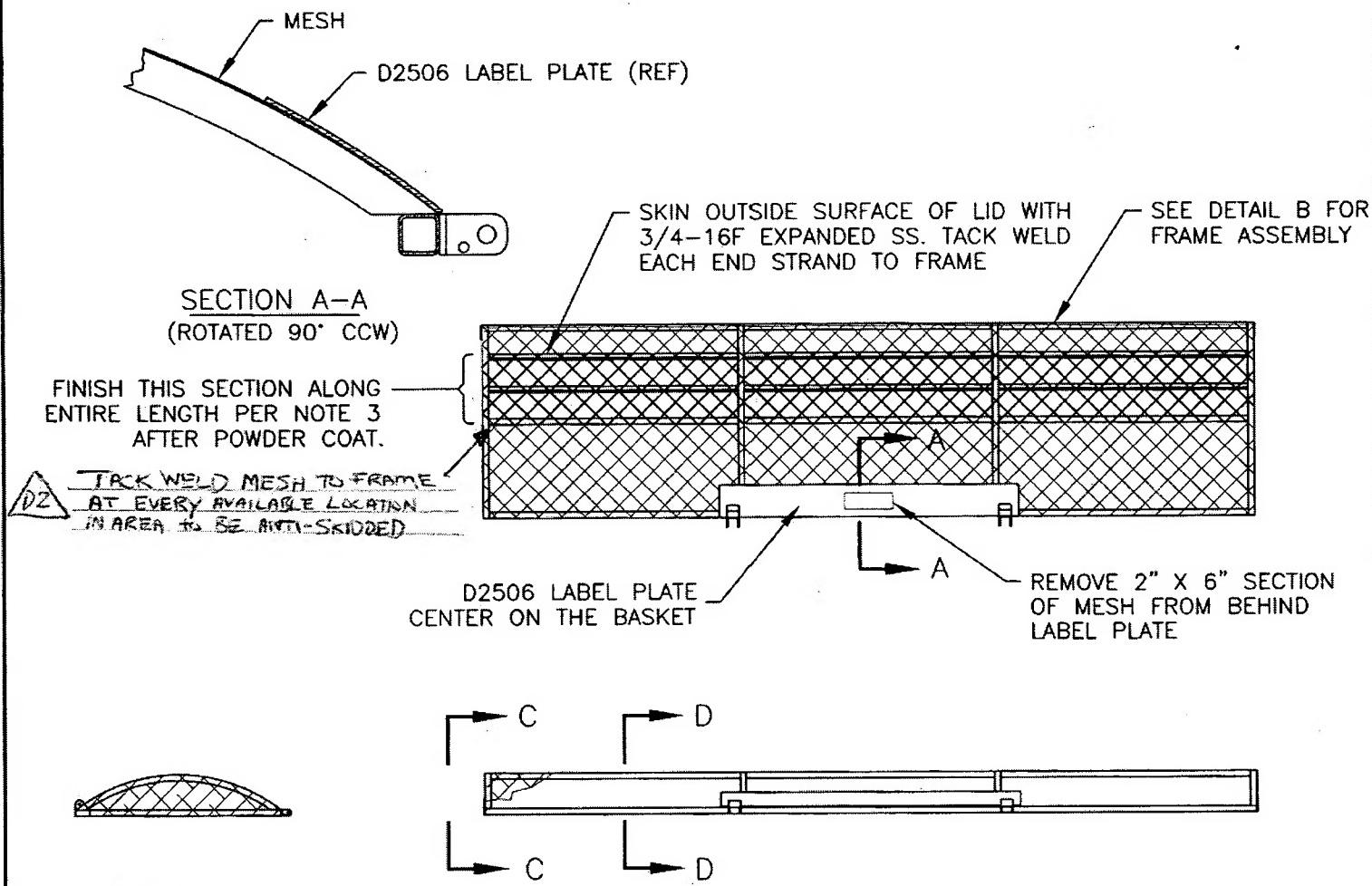
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DATE 01.04.19	DRAWING NO. D2512	REV. D
	TITLE BASKET LID ASSEMBLY (350/212)	SHEET 2 OF 4 SCALE 1:20

**D2512 BASKET LID ASSEMBLY**

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

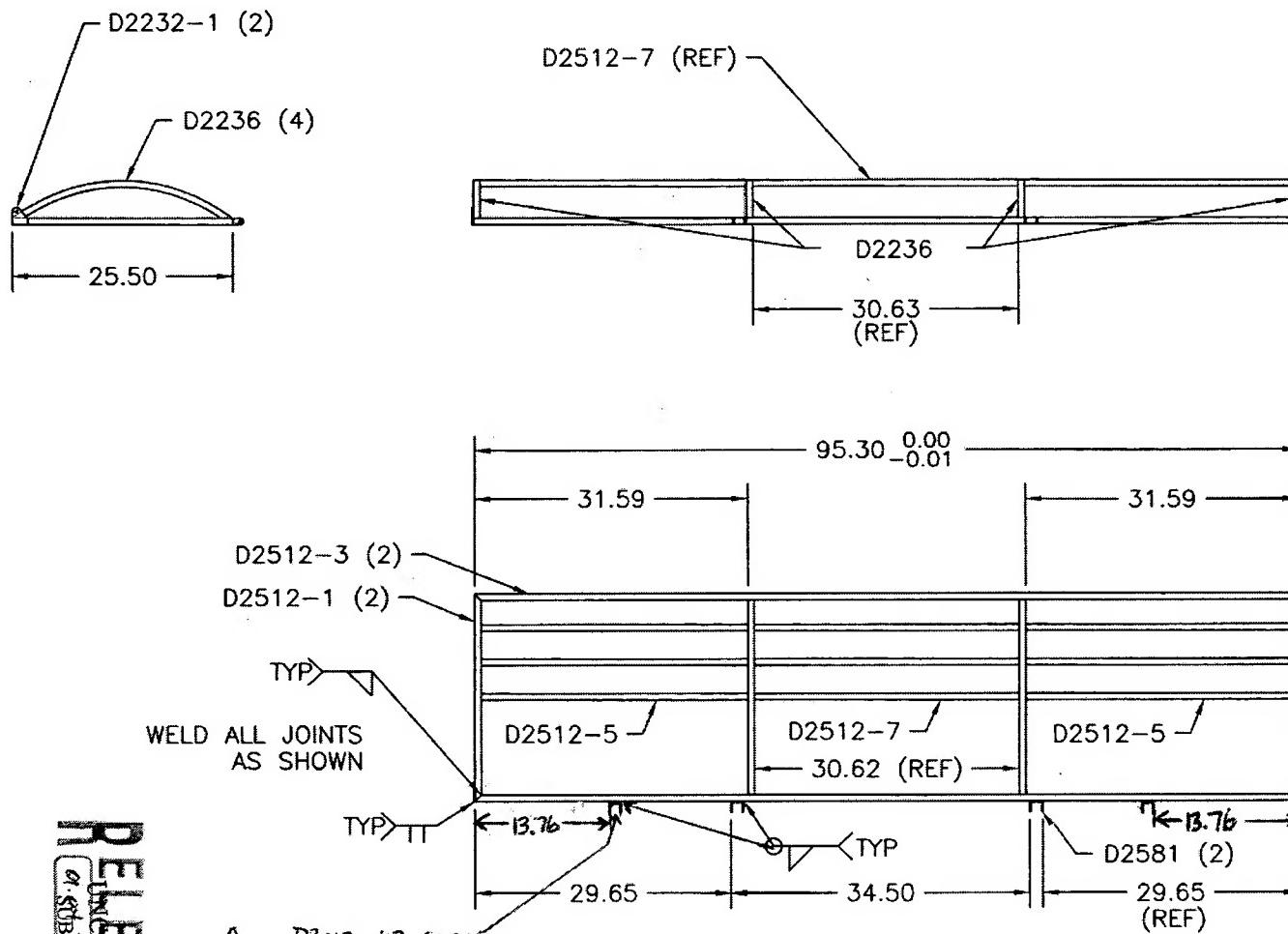
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DATE 01.04.19	TITLE D2512	REV. D
	BASKET LID ASSEMBLY (350/212)	SHEET 3 OF 4

SCALE

1:20



DETAIL B
FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

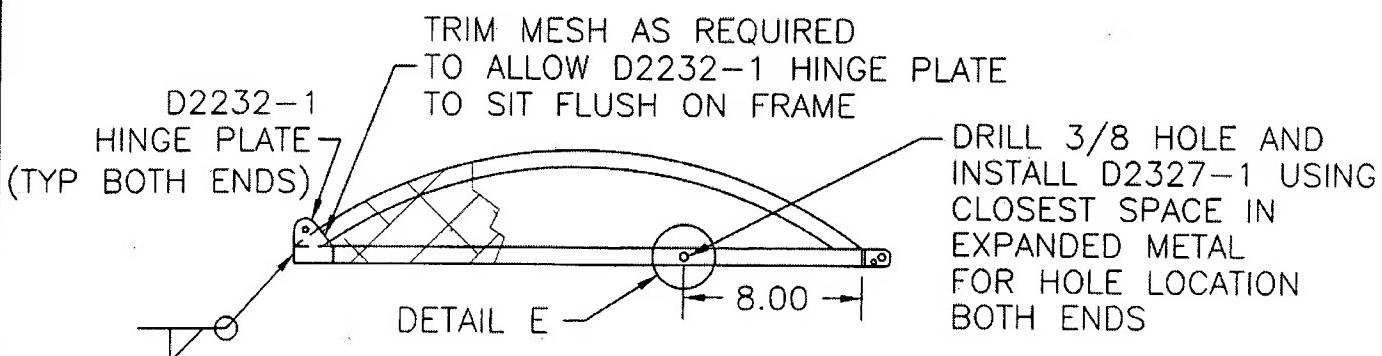
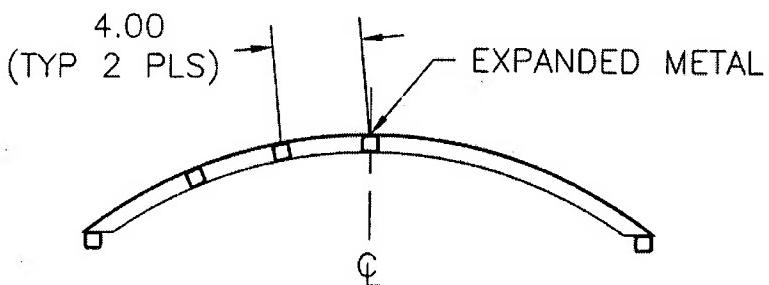
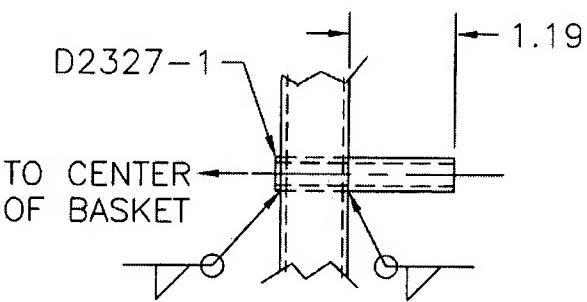
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DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8

SECTION C-C SIMILIAR BOTH END RIBSSECTION D-D SAME BOTH CENTER RIBS

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